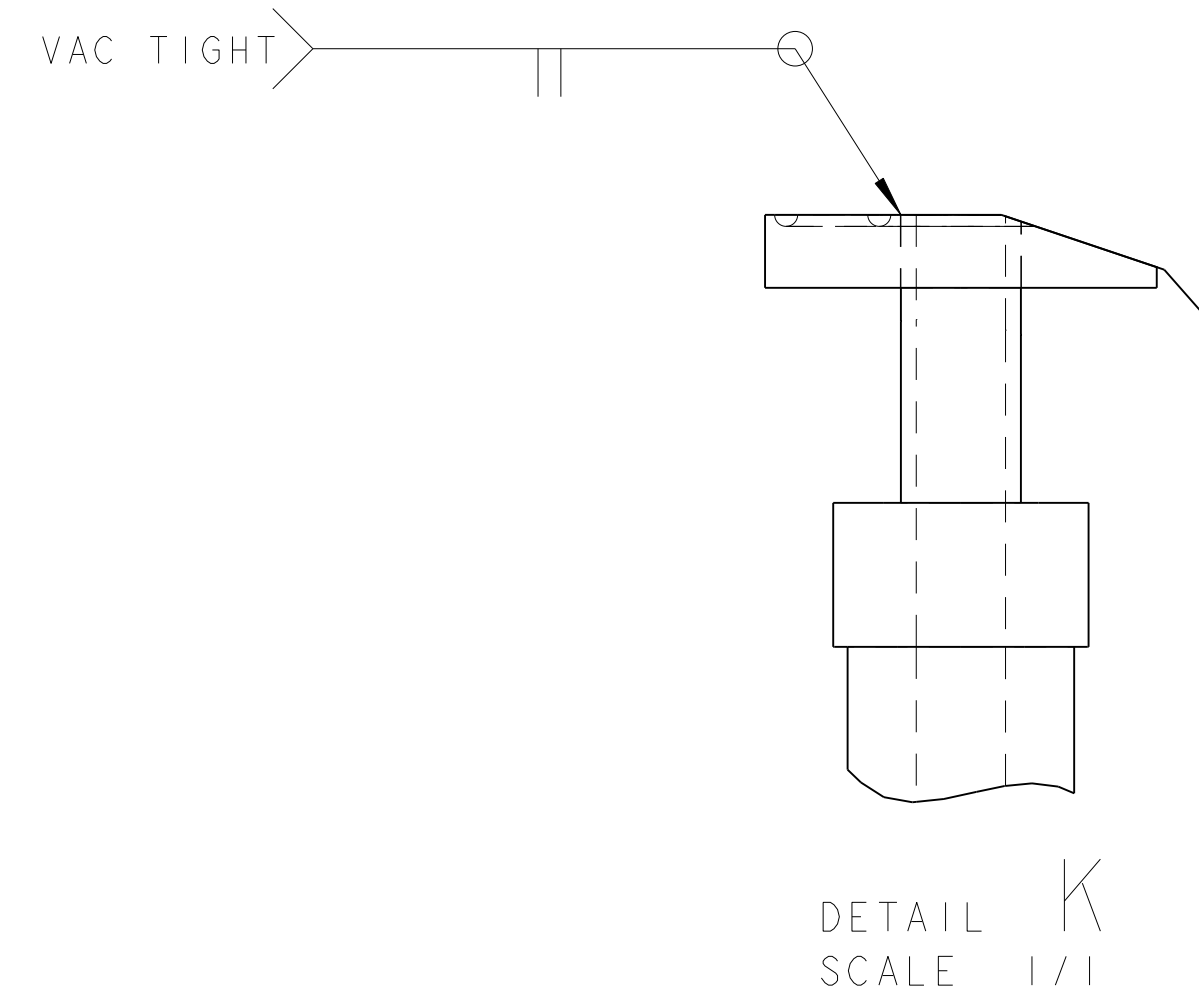
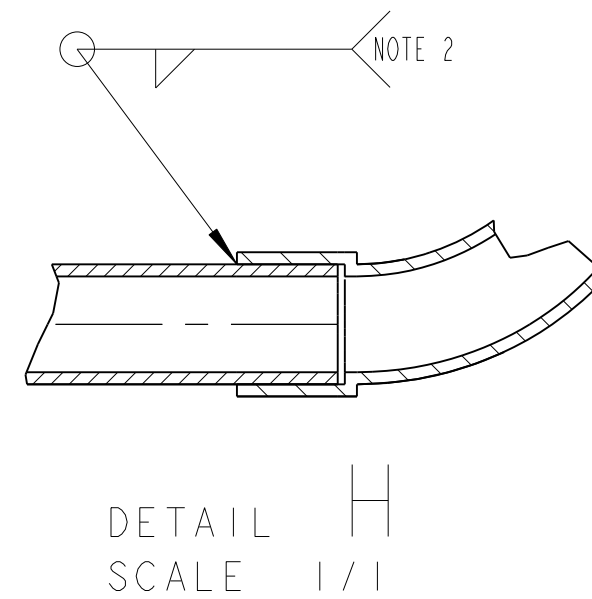
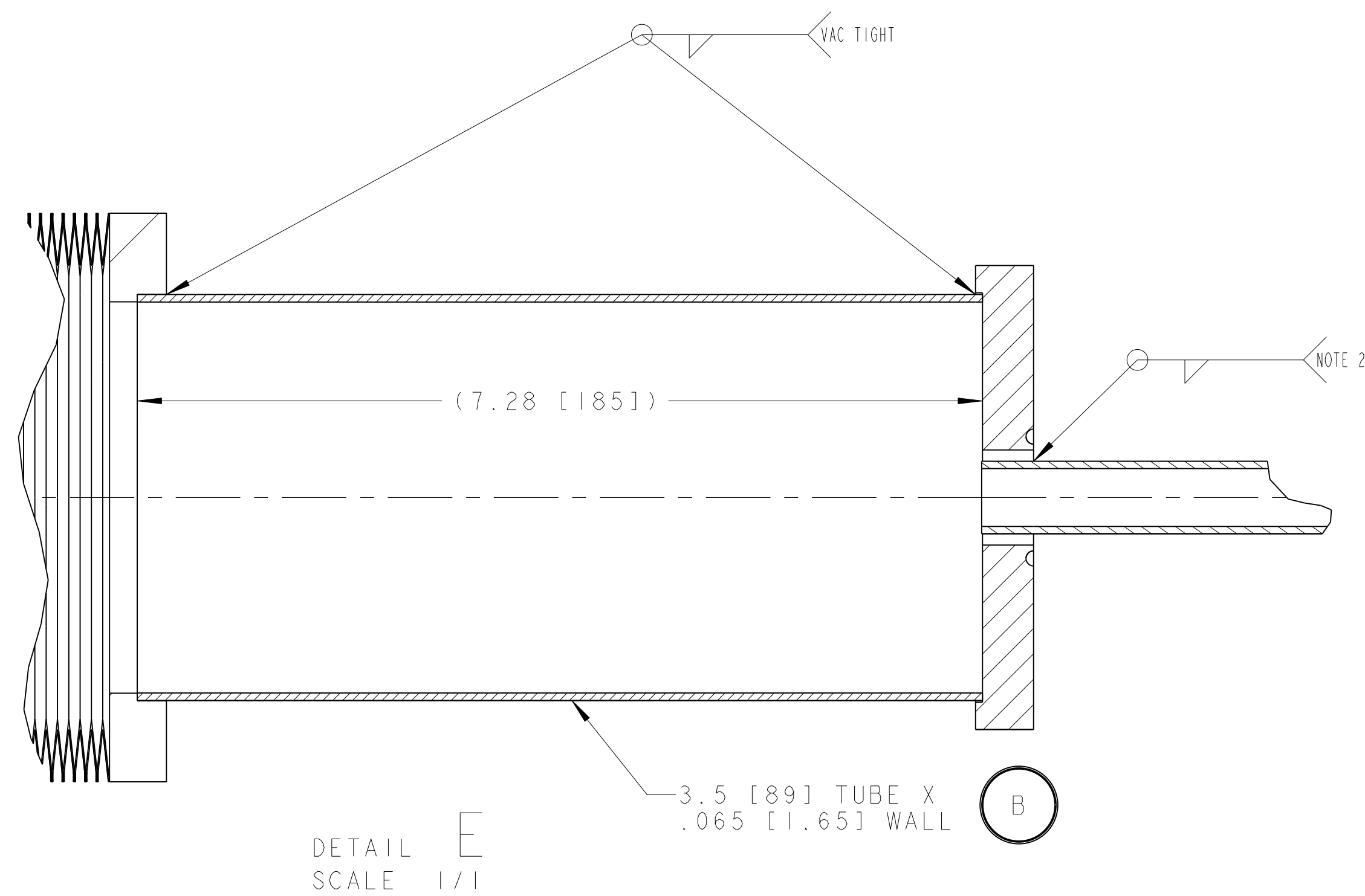
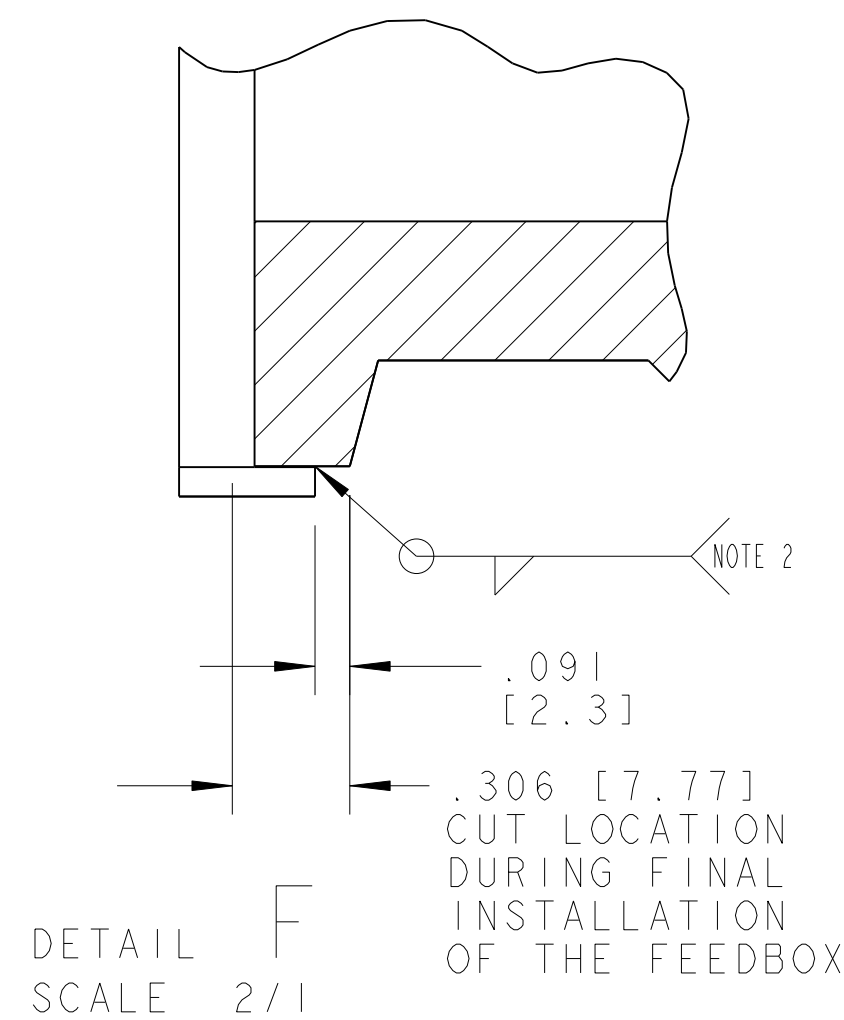
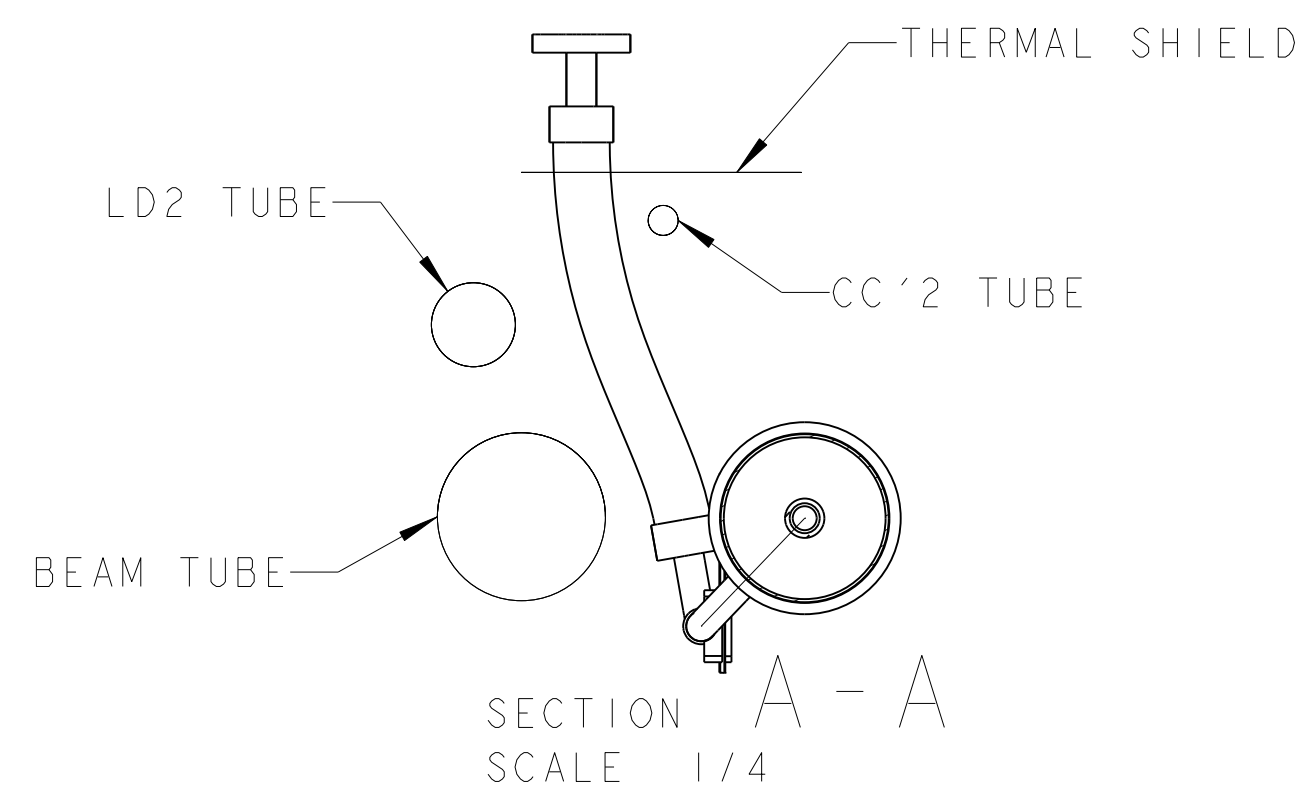
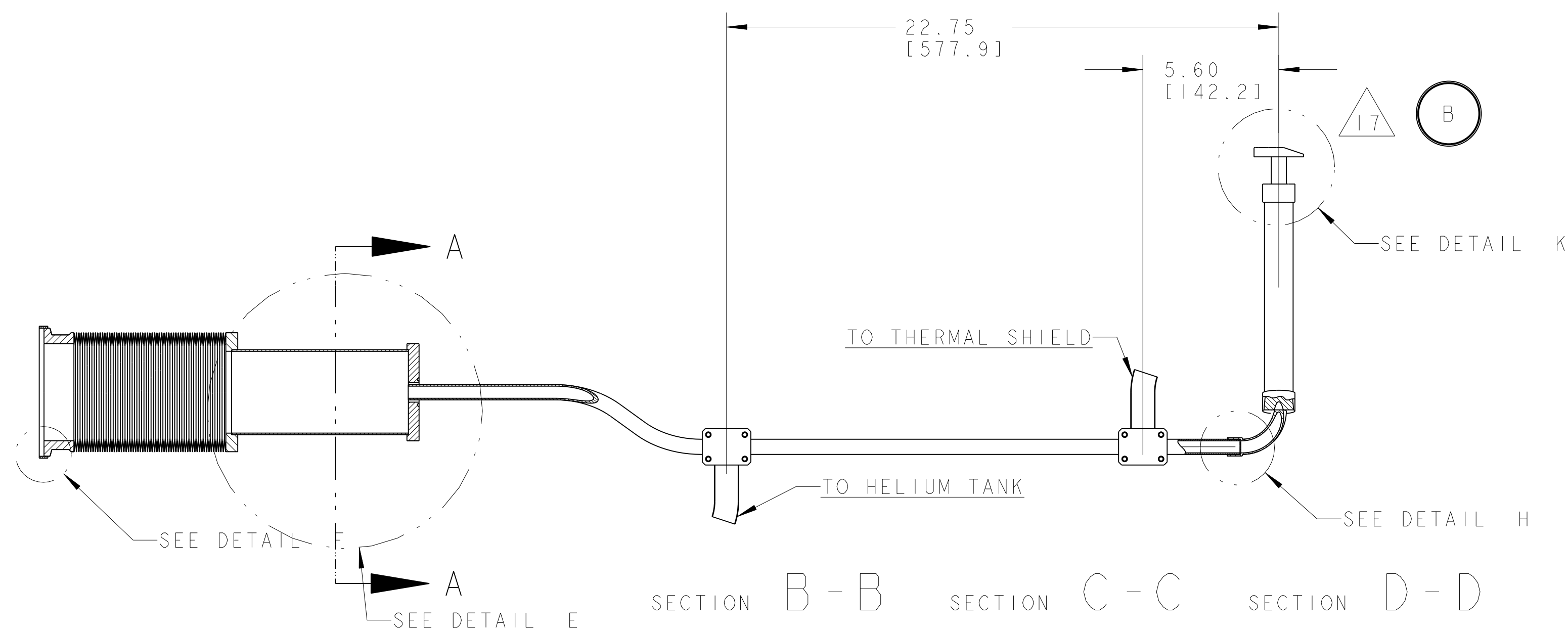
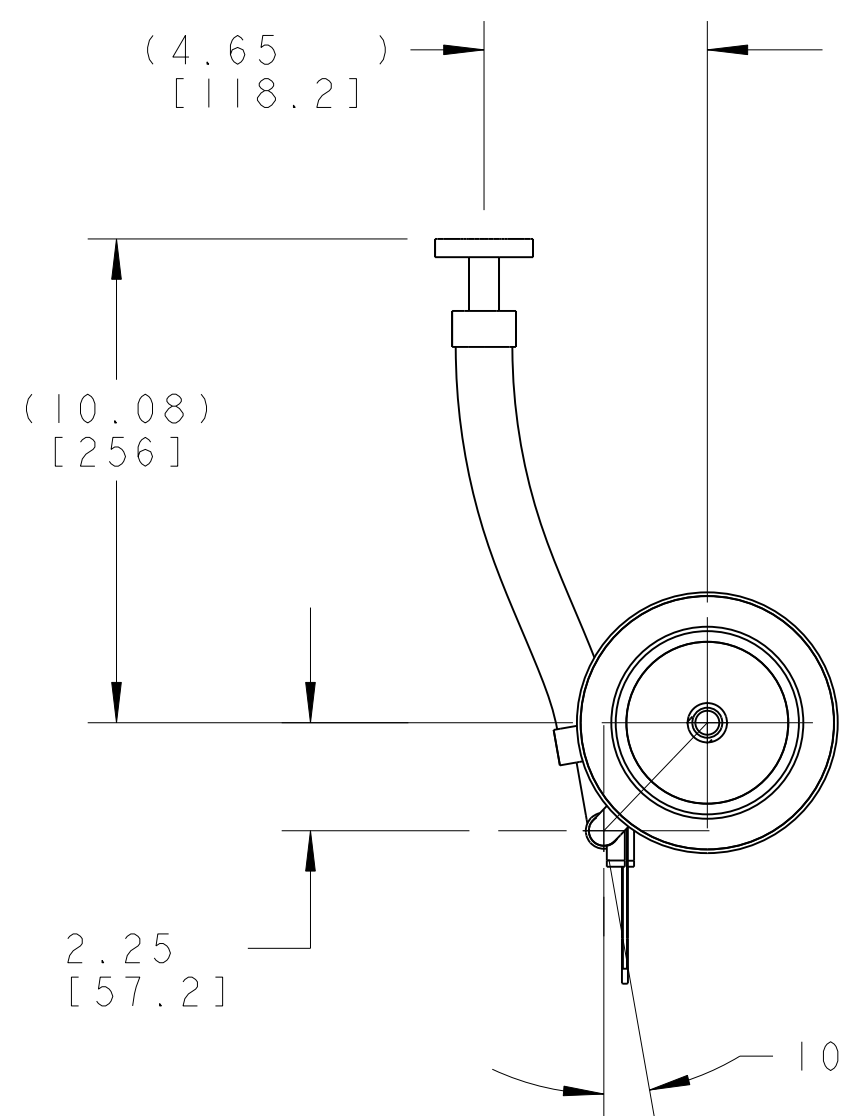
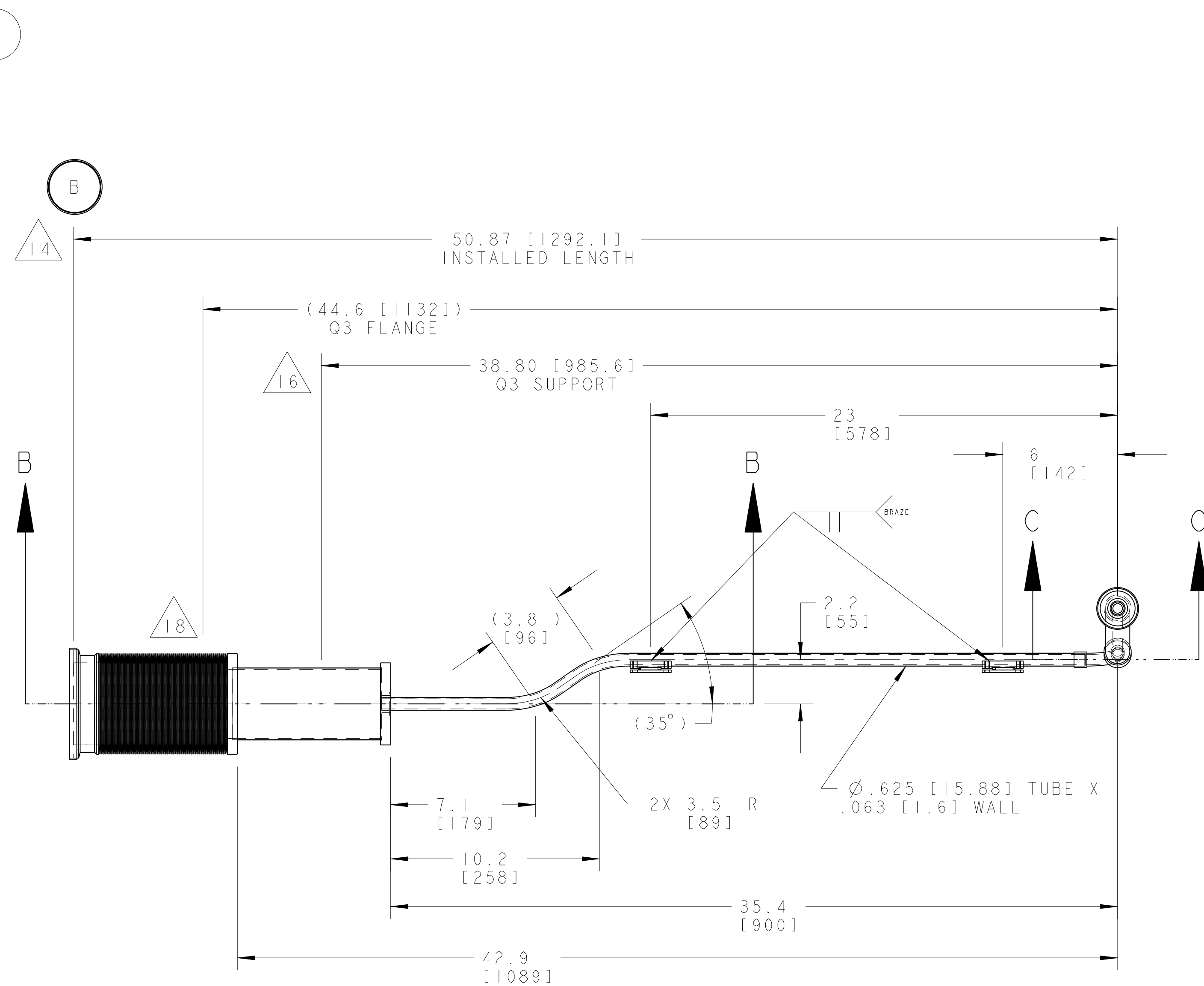


1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS. SUBJECT TO LBNL APPROVAL
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN $\pm .010$.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. B
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ± 0.063 ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP END OF PIPE TO FACILITATE ACCEPTANCE TESTS. B
18. PIPE SHIPPED WITH CAPPED TUBE WELDED TO BELLWS FLANGE. THE TUBE WILL BE CUT AS SHOWN AND USED AS A WELD SLEEVE DURING FINAL INSTALLATION OF THE FEEDBOX.
19. THE INTERIOR OF ALL COMPONENTS MUST BE FREE OF BURRS TO PREVENT WIRE INSULATION FROM ABRASION DURING THERMAL CYCLING.



10	25M959	1	WELD RING, ID 134mm		SS 304L
9	25M877	2	CLAMP BASE PLATE, 5/8" TUBE	COOPER, OFHC, C101	
8	25M813	2	CLAMP COVER 1"	OFHC, C101	
7	251641	1	INSERT, 5/8" TUBE WELD FLANGE		SS 304L
6	251300	1	WELD CONNECTOR, M0X2		SS 304L
5	-	1	TUBE, PER ASTM A269		SS 304L
4	-	1	TUBE, PER ASTM A269		SS 304L
3	-	2	COPPER BRAID, 1" X 1/8"		-
2	-	1	BRAIDED FLEX HOSE, 3/4" ID, 8.2'LL		SS 300 SERIES
1	-	1	RFIHOUS, ENAI # 5520-MR-390073		SS 300 SERIES

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		DATE DESIGNED DATE CHECKED DATE DRAWN DATE	
TOLERANCES:	F.X ± 0.1	F.BAC ± 0.03	ACE ± 0.01	ERNEST W. ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA BERKELEY	
	F.XX ± 0.03	FINISH 12-20	1/16 ± 0.005		
	F.XXX ± 0.010	FINISH 12-20	1/32 ± 0.005		
	DO NOT SCALE PRINT	DO NOT SCALE PRINT	DO NOT SCALE PRINT		
THERMALS ARE CLASS 2			LHC IR FEEDBOX		
CHAMFER ENDS OF ALL CROSS THREADS 30°			CROGENICS		
CUT THREADS: 1.5 THREADS LEFT ON MACHINED THROAT CUT THREADS: 0.5 THD. ON MACHINED THROAT HEMM. HOLE: 180° SPALLER 1.000 SCALE IN ACCORDANCE WITH ASME Y14.5 & B.01			PIPE, MQX2		
MICROFILMED: DWG. TYPE: _____ SHOWN ON: _____ SCALE: 1/4			SHEET 1 OF 1 SIZE: B		
PATENT CLAIMED: DESIGN ACCT. NO. _____ CATEGORY CODE: _____ LHM2003			253016		

[illegible]

THIRD ANGLE PROJECTION